

5/2008 1:20:02 PM

Process Sheet

2001 Dart Helicopters Services	Drawing Name	: PIVOT ARM
13/05/2008 S.O. No. :	Part Number	: 41232 200 002 005
NC	Drawing Number	: 41232-200-002 REV A
13/05/2008 Type : MACHINED PARTS	Project Number	: N/A
31778	Drawing Revision	: A
<i>JLM 08-05-13</i>	Material	:
	Due Date	: 05/06/2008 Qty: 6 Um: Each
Written By		
Checked & Approved By		
Comment	Est Rev:A New Issue 07-03-05 JLM Est Rev:B Now on Doosan Lathe 08-05-13 JLM Verified By:DD	
Additional Product		
Job Number:		
Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3R1250	2024-T3 Round Bar 1.250"
		
Comment: Qty.: 0.3675 f(s)/Unit Total : 2.2050 f(s) 2024-T3 Round Bar 1.250" Batch: <i>01 103 753</i> <i>20 08/05/14</i>		
2.0	DOOSAN LATHE	DOOSAN LATHE
		
Comment: Doosan Lathe		
1- Turn as per Folio FA745 Rev: <i>A</i> & Dwg 41232-200-002 Rev: <i>A</i> <i>20 08/05/14</i>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>20 08/05/14 (7)</i>		
4.0	QC8	SECOND CHECK
		
Comment: SECOND CHECK <i>20 08-06-18 (7)</i>		
5.0	OUTSIDE SERV.30	OUTSIDE SERVICES-MACH
		
Comment: Sub-Contracting PURCHASING Issue P/O: <i>0520</i> <i>C 208106/06 (7)</i> Black Anodize as per Dwg 41232-200-005 Ensure Certificate of Conformity is attached		

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PIVOT ARM

Job Number: 39217

Part Number: 41232 200 002 005

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage
Ensure certificate of conformity is attached

P.L.M./S (8)

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0 MS21209F410

heli-coil



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

HeliCoil 1/4"-28NF(RED)

Batch:

M104030 x 4 M108085 x 3

AS 08/06/23 (X)

9.0 MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Install Helicoil as per Dwg 41232-200-005.

FF 08-06-24 (7)

10.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/06/24 (4)

11.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 365

AS 08/06/24 (X)

12.0 QC21

FINAL INSPECTION/W/O RELEASE



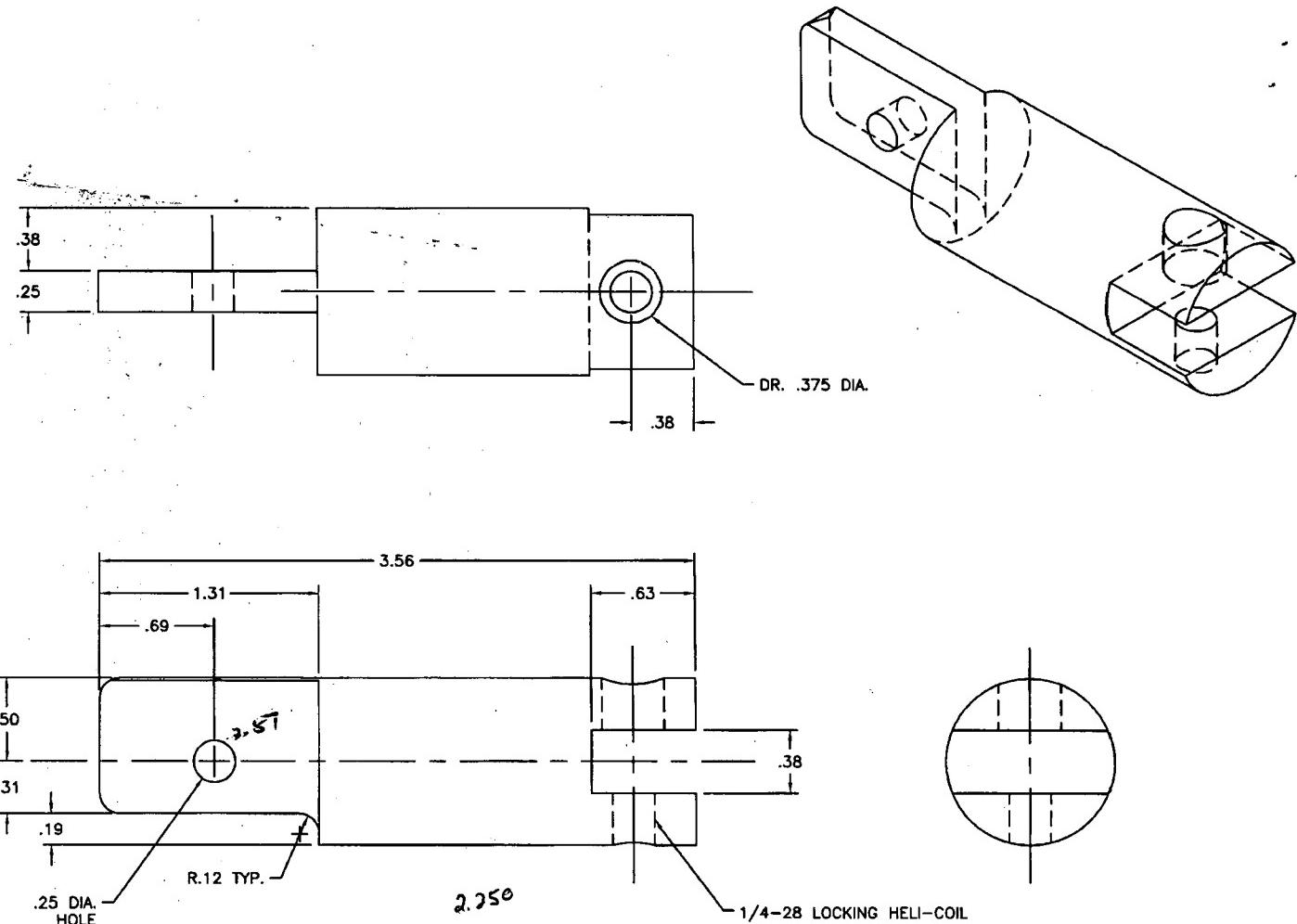
Comment: FINAL INSPECTION/W/O RELEASE

08/06/25 (J)

Job Completion



C 08/06/25



-005 PIVOT ARM

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WORK ORDER
NO. 39217

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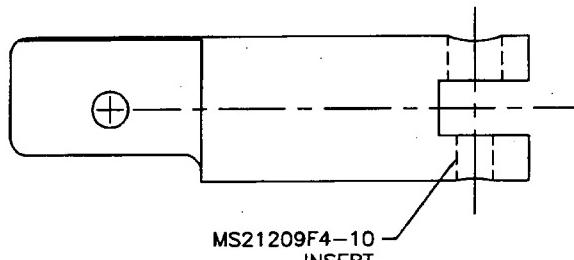
TITLE	REV.
STEP ACTUATOR COMPONENTS	A

SIZE C DATA NO. 41232-200-002
SHT 3 OF 3

DATE 2/26/04	ENGINEERING ORDER		E.O. No. B-1	SHT. 1 OF 1
BY D. NELSON	TITLE STEP ACTUATOR COMPONENTS	DWG. AFFECTED 41232-200-002		
APPROVED BY		SHEET AFFECTED SHT 1 & 3		
REASON FOR CHANGE: CHANGED DASH NO. OF INSERT ON L/M; CHANGED INSERT CALLOUT ON -005 PIVOT ARM.				
MINOR CHANGE - FAR 21.95				

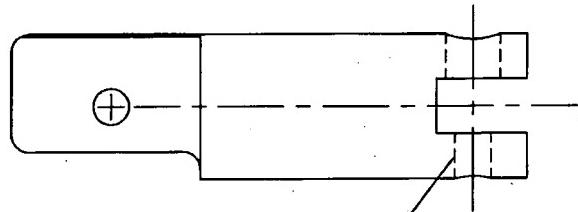
IS | 1 | MS21209F4-10 | INSERT

WAS | 1 | MS21209F4-15 | INSERT



MS21209F4-10
INSERT

-005 PIVOT ARM



1/4-28 LOCKING HELI-COIL

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CHANGE REQUIRED:	DATE:	BY:	YES	NO
TRAVELER				
INSTALLATION INSTRUCTIONS				
MAINTENANCE INSTRUCTIONS				
ILLUSTRATED PARTS				
UNINCORPORATED DRAWING LIST				
MASTER DRAWING LIST				
COMPUTER DATA BASE				

DART AEROSPACE LTD	Work Order:	39217
Description: PIVOT ARM	Part Number:	41232-200-002-005
Inspection Dwg: 41232-200 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:		Audited by:		Prototype Approval:	
Date:	08/05/14	Date:	08-03-14	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

TNM

**ANODISATION et PEINTURE TNM INC.**

C. OF C

21 chemin de l'Aviation, Pointe Claire QC H9R 4Z2

Telephone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001-2000 certified

approuvé NADCAP approved

65597

11-Jun-2008

CLIENT / CUSTOMER:

DART AEROSPACE LTD.

1270 ABERDEEN STREET

HAWKESBURY . ONTARIO

K6A 1K7

**CERTIFICATE OF COMPLIANCE
CERTIFICAT DE CONFORMITE****NO. DE COMMANDE: 6520
PURCHASE ORDER/**

ITEM ORDERED	COMMANDÉ ORDRE	EXPIÉDIE SHIPPED	PART NUMBER & DESCRIPTION	PART PROCESS & TREATMENT
1	7	7	412-200-002-005 B39	DWG: D41232-200-002 REV. A
4	8	8	D3299-1 B38451	BLACK ANODIZE PER MIL-8625F1, CLASS 2 TYPE 2 DWG: D2399 REV. B
2	62	62	D2348 B39578	BLUE ANODIZE PER MIL-8625F1, CLASS 2 TYPE 2 DWG: D2348 REV. B2
3	62	62	D2348 B39666	BLACK ANODIZE PER MIL-8625F1, CLASS 2 TYPE 2 DWG: D2348 REV. B2
BLACK ANODIZE PER MIL-8625F1, CLASS 2 TYPE 2				

Last Modified on 20-Jun-2008

Nous certifions que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées.
 Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.

All parts are processed, tested, and inspected to the requirements of above specifications.
 Travel cards have been filled and are available for viewing upon request.

NOTE: Painted Parts will be Fully Solvent Resistant after 7 (seven) Full Days of Air Curing at Ambient Temperatures"

NOTE: Les pièces peintes seront complètement résistantes au solvant après 7 (sept) jours complets de séchage à l'ambiant.

Signature/Signed:

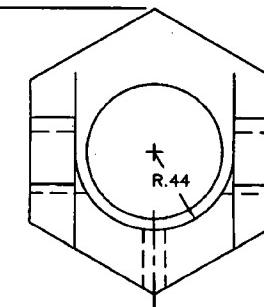
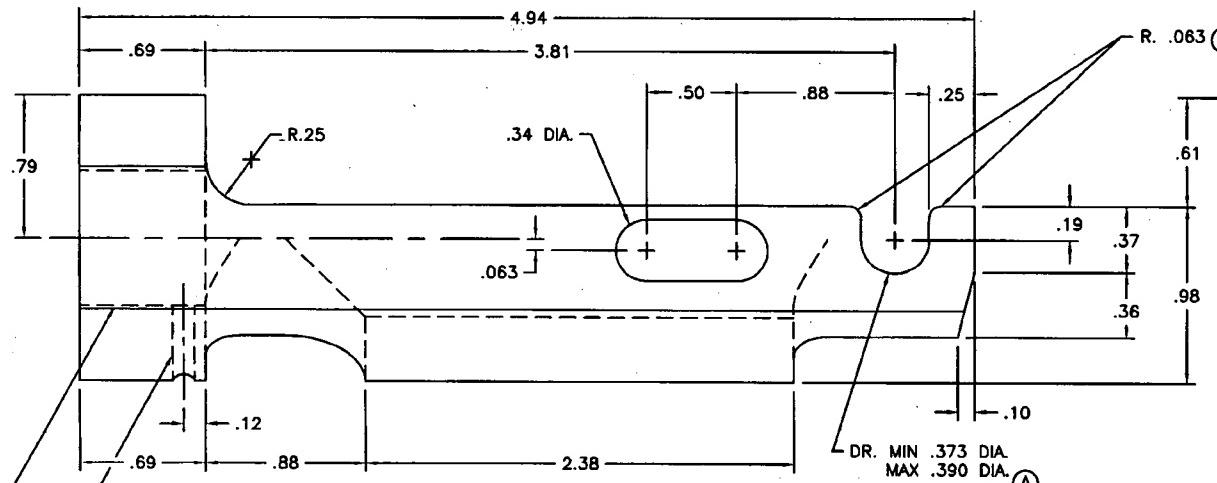
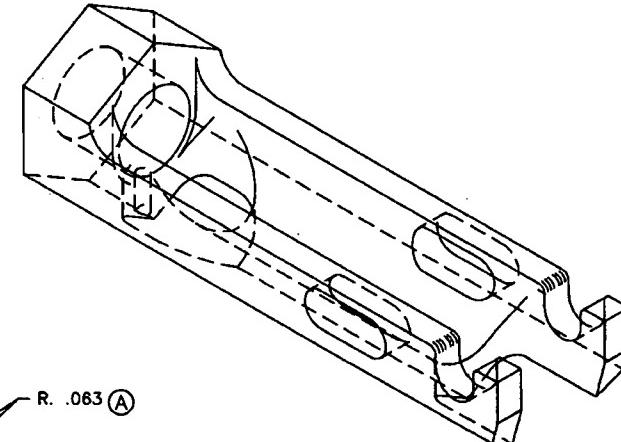
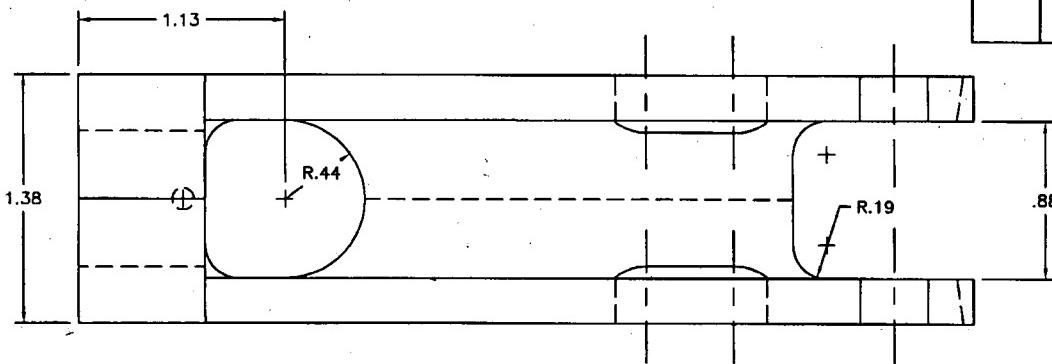
Directeur de la Qualité / Q.A. Manager [Signature]

REVISION

DESCRIPTION

APPROVED DATE

LETTER	DFTSMAN	DATE	DESCRIPTION	APPROVED	DATE
A	DNN	2/17/03	ADDED SMOOTH EDGES TO -001 & -003; REDUCED LENGTH OF -003 BY .125"; ADDED DRAIN HOLE TO -001; INCREASED DIA. OF AFT SLOT ON -001. MINOR CHANGE - FAR 21.95 CHECK D. MURPHY 2/17/03		

-001 TUBE

DR. .12 DIA. DRAIN HOLE
(NOTE: SPOTFACE IF REQ'D
TO DRILL HOLE)

3/4"-20 THD,

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⚠ ANODIZE IN ACCORDANCE WITH MIL-A-8625, TYPE II, CLASS 2
DYED BLACK.

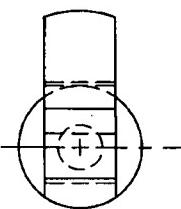
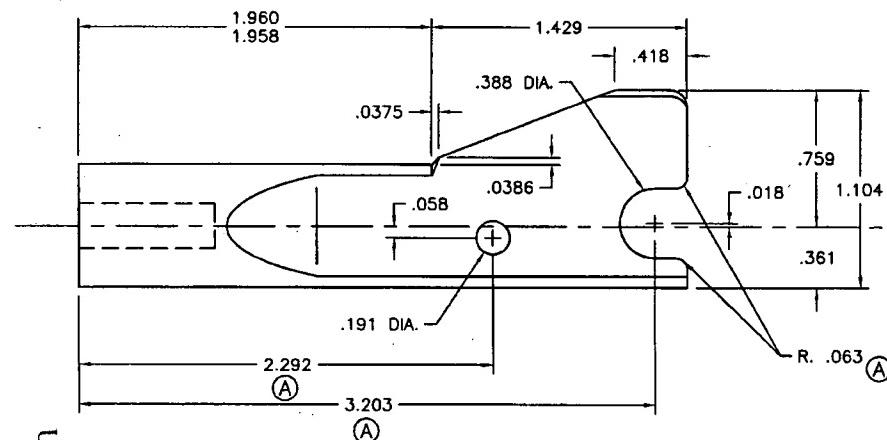
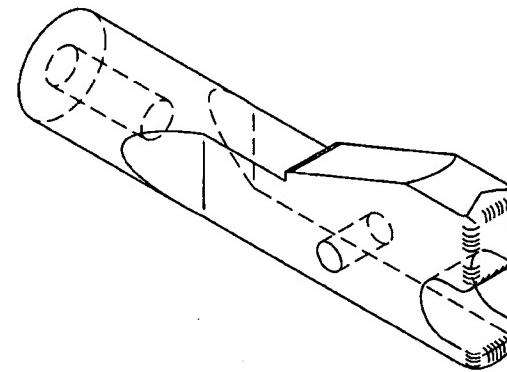
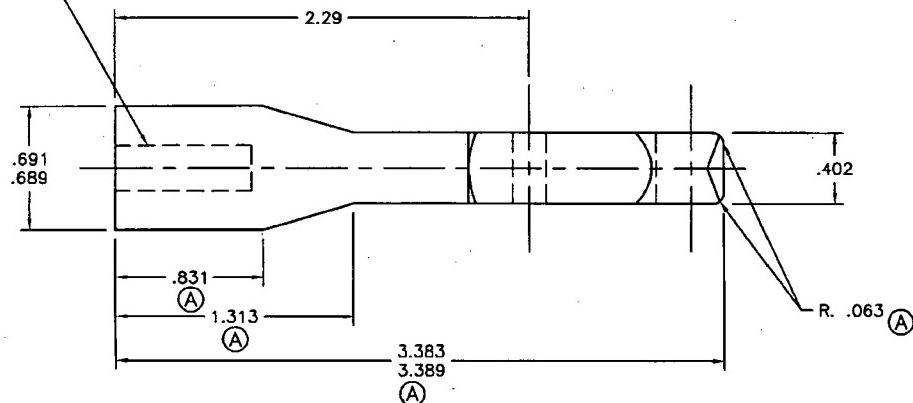
NOTE:

NO. REQ'D PER ASSY	1	MS21209F4-15	INSERT			
		-005	PIVOT ARM	△	1.00 DIA. x 3.56	2024-T4, T351 ALUM.
		-003	LATCH	△	1.11 x 3.50	2024-T4, T351 ALUM.
		-001	TUBE	△	1.38 HEX STK. x 4.94	2024-T4, T351 ALUM.
	-005	PART NO.	NAME		STOCK SIZE	MATERIAL

LIST OF MATERIAL

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			X±.1	CHECK	D. MURPHY	
		XL±.03				STEP ACTUATOR COMPONENTS
		XXOL±.010				
		ANGLES ±.1/2"				
			PROJ.			
			ENGR.			
			HEAT TREAT			
			FINISH	△		
						DWG. NO.
						41232-200-002
						SHT 1 OF 3
						REV. A

.625 + 1/16/-000
DRILL DEPTH TO 1.000 MAX
AS NEEDED FOR THREAD.



-003 LATCH

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TITLE	SIZE	REV.
STEP ACTUATOR COMPONENTS	C	A 41232-200-002 SHT 2 OF 3